



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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Rush !!!

D3290-1

Job Sheet 185964



Part No: D3290-1

Job Qty: 8 ea

Part Name: Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/18

Job Tracking No:

Due Date: 11/29/18

Created By: Marie Lajeunesse

Type: ~~Steel~~ *sold*

Description:

Note: DWG REV C IPP REV:A 12.06.13 NEW ISSUE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		11/29/18	0.00	1.67	Waterjet - Flow		<i>DR 18/12/18</i>
120	QC	8 pcs		11/29/18	0.00	0.00	QC8		<i>38</i>
130	HandFinish	8 pcs		11/29/18	0.00	0.54	HandFinish1		<i>DR 18/12/18</i>
135	QC	8 pcs		11/29/18	0.00	0.00	QC7-2		<i>DR 18-12-18</i>
140	Powdercoat	8 pcs		11/29/18	0.00	0.38	Powdercoat1		<i>DR 18-12-18</i>
150	QC	8 pcs		11/29/18	0.00	0.00	QC3		<i>DEC 24 2018 62</i>
180	Packaging	8 pcs		11/29/18	0.00	0.00	Packaging3-1	<i>5143288</i>	<i>DEC 27 2018 68</i>
190	QC21-SA	8 Ea		11/29/18	0.00	0.00	QC21		<i>DEC 27 2018 70</i>

M 138951 START: 8:50 AM 12/30/18 FINISH: 9:40 AM

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	30 sf (3.75 ea)	100-Waterjet - Flow - 1	<i>S136472</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	30	176	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Window Frame	29.000inches ± 0.030	29.030 28.970		
2	Window Frame	14.000inches ± 0.030	14.030 13.970		
3	Window Frame	0.171inches + 0.005 - 0.001	0.176 0.170		
4	Window Frame	1.500inches ± 0.030	1.530 1.470		
5	Window Frame	1.110inches ± 0.030	1.140 1.080		
6	Window Frame	10.100inches ± 0.030	10.130 10.070		
7	Window Frame	18.500inches ± 0.030	18.530		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

			18.470	
8	Window Frame	0.063inches $\pm$ 0.010	0.073 0.053	
9	Window Frame	3.000inches $\pm$ 0.030	3.030 2.970	
10	Window Frame	4.500inches $\pm$ 0.030	4.530 4.470	
11	Window Frame	0.257inches + 0.006 - 0.001	0.263 0.256	
12	Window Frame	13.610inches $\pm$ 0.030	13.640 13.580	

Plex 11/7/18 1:28 PM Dart.lajeunesse.marie



Container No: S137126



Part: D3290-1

Job No: 185964

Serial No/Batch: S137126

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/12/18

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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